

METHOD OF AND APPARATUS FOR MAKING AND PROCESSING  
ROD-SHAPED ARTICLES

ABSTRACT OF THE DISCLOSURE

1 Filter cigarettes of unit or multiple unit length  
2 are produced in a tipping machine wherein successive  
3 groups of coaxial plain cigarettes and filter rod sec-  
4 tions are caused to roll within a channel bounded by  
5 surfaces at least one of which moves relative to the  
6 other(s). This results in the conversion of uniting  
7 bands, which are carried by successive groups into the  
8 inlet of the channel, into tubular sleeves connecting  
9 the tubular wrapper(s) of the filter rod section(s) to  
10 the plain cigarette(s) of the respective group. The  
11 wrappers, and normally also the uniting bands, are  
12 perforated in the channel subsequent to, or in part si-  
13 multaneously with, the conversion of uniting bands into  
14 the respective sleeves. Each filter cigarette can be  
15 provided with one or more arrays, such as annuli, of  
16 perforations, e.g., by mutually inclined laser beams.  
17 Rolling movements of successive groups can be  
18 accelerated in several stages during and subsequent to  
19 entry into the channel, and this also applies for the  
20 deceleration of rolling movement ahead of, at and down-  
21 stream of the outlet of the channel.